

Date: Thursday, 23/10/2008 10:54:02 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number : 42884	
Estimate Number : 12924	
P.O. Number :	Part Number : D29321UP
This Issue : 23/10/2008 S.O. No. :	Drawing Number : D2932 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 41721	Material :
Written By :	Due Date : 15/11/2008
Checked & Approved By : <u>JLD 08-10-23</u>	Qty : 6 Um: Each
Comment : Est Rev:A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Issue material from stock:
 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length
 Batch No: 13 34873

SF 08/10/28

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 5-Deburr & TUMBLE

SF 08/10/28

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

SF 08/11/07

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SF 08/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:54:02 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 42884

Part Number: D29321UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/11/07

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-H 08/11/10

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1023

8/11/10

1023

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12

Job Completion



mf 08-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42884
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.106	.106	.107	.105		
B	0.100	0.140		.106	.106	.108	.108		
C	0.100	0.140		.120	.120	.120	.120		
D	0.210	0.230		.220	.220	.220	.214		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.257		
L	0.312	0.317		.318	.318	.318	.318		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.108	.108	.108	.109		
O	0.540	0.560		.551	.551	.551	.549		
P	0.490	0.510		.505	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.250	.250	.250	.245		
T	0.100	0.180		.170	.170	.170	.170		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.317	.317	.317	.317		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>JP</u>
Date: <u>08/10/28</u>

Audited by: <u>JL</u>
Date: <u>08/11/07</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42884
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5 X	6 X	7 X	8 X		
A	0.100	0.140		.105	.105	.105	.105		
B	0.100	0.140		.108	.107	.108	.108		
C	0.100	0.140		.120	.120	.120	.120		
D	0.210	0.230		.215	.215	.215	.215		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.110	.110	.110	.110		
O	0.540	0.560		.550	.550	.556	.550		
P	0.490	0.510		.500	.500	.499	.499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.250	.250	.246	.246		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.144	1.144	1.144		
Y	1.565	1.585		1.575	1.575	1.575	1.582		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>JB</i>	Audited by: <i>SL</i>
Date: 08/10/29	Date: 08/11/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

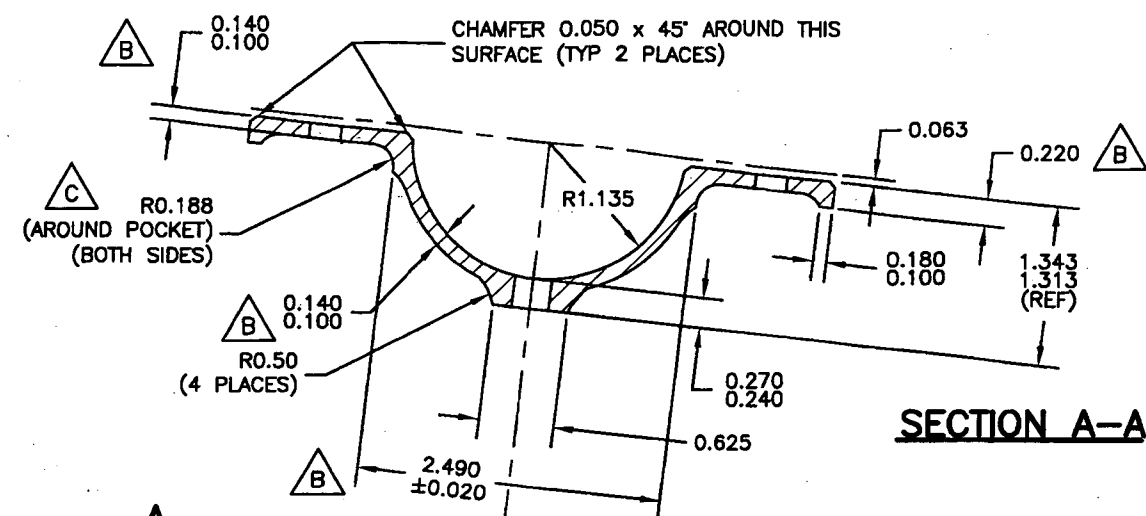
DART AEROSPACE LTD	Work Order: 42894
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

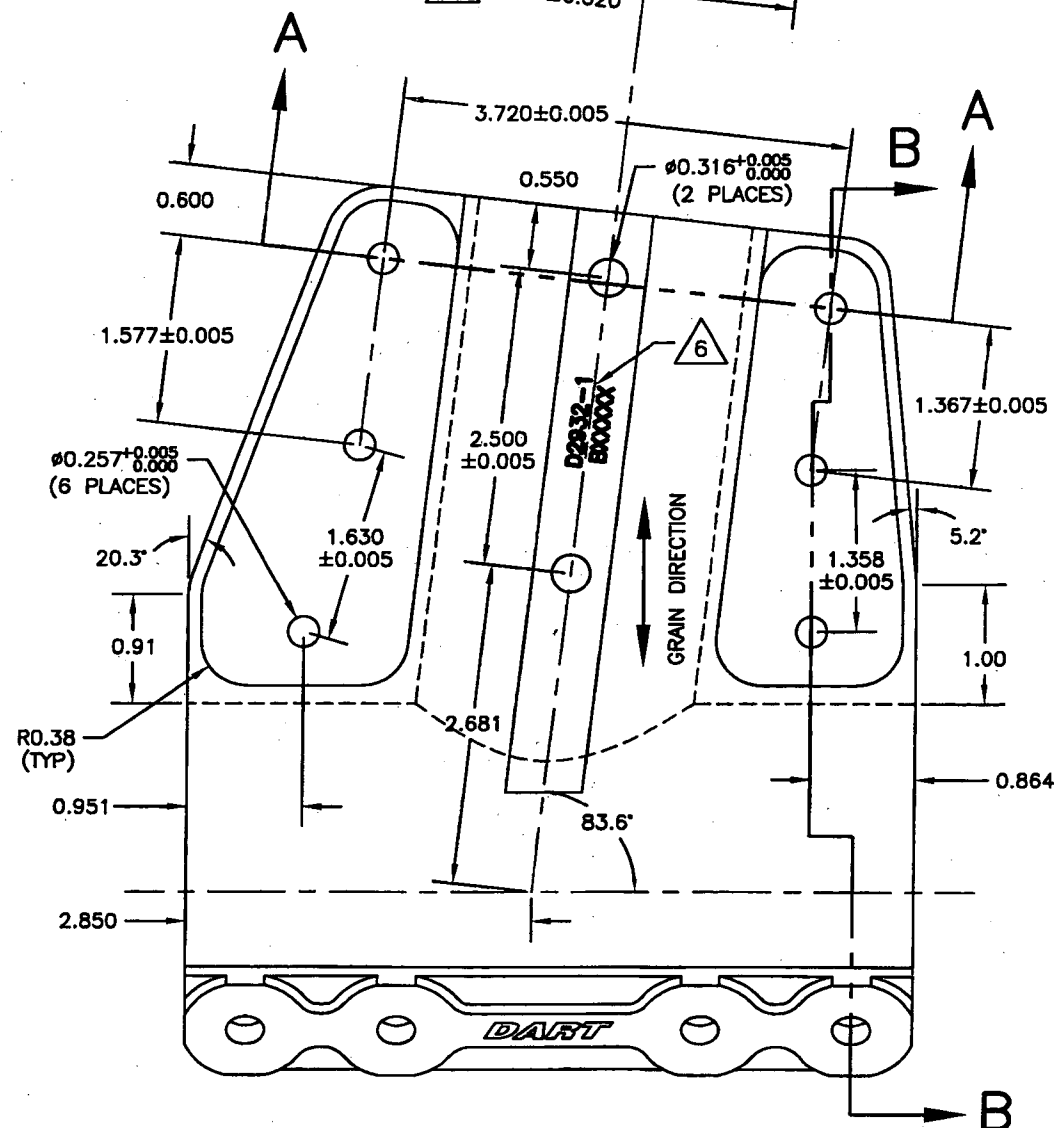
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.103	.108				
B	0.100	0.140		.105	.105				
C	0.100	0.140		.114	.119				
D	0.210	0.230		.215	.214				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.257	.251				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.234	.238				
N	0.100	0.140		.110	.112				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.500	2.500				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.370	1.370				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.140	1.145				
Y	1.565	1.585		1.580	1.580				
Z	0.178	0.198		.184	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>SB</i>	Audited by: <i>SL</i>
Date: 05/10/29	Date: 08/11/07

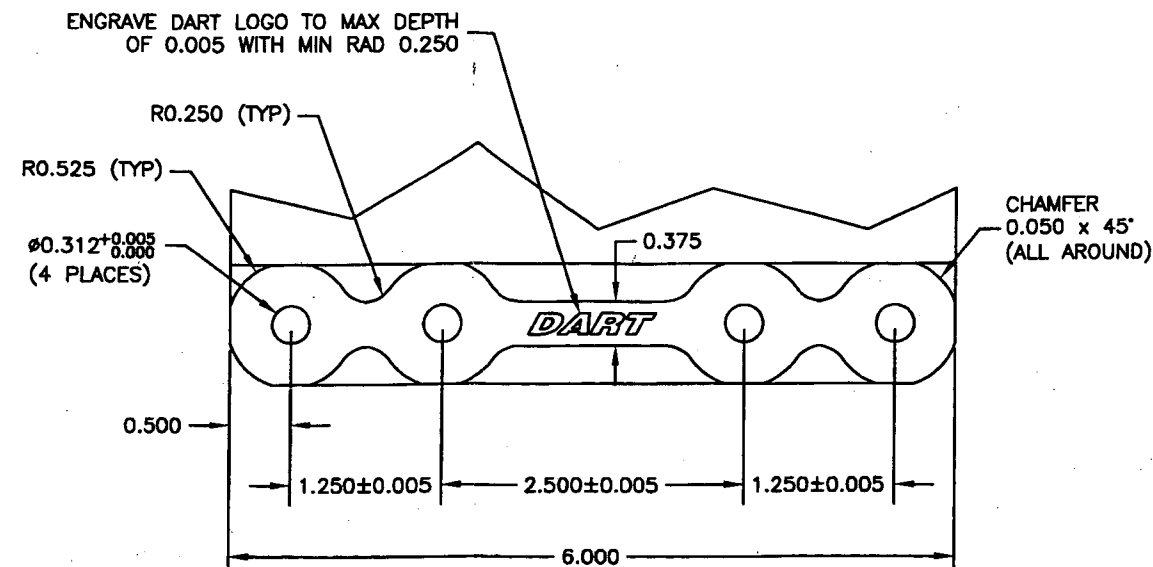
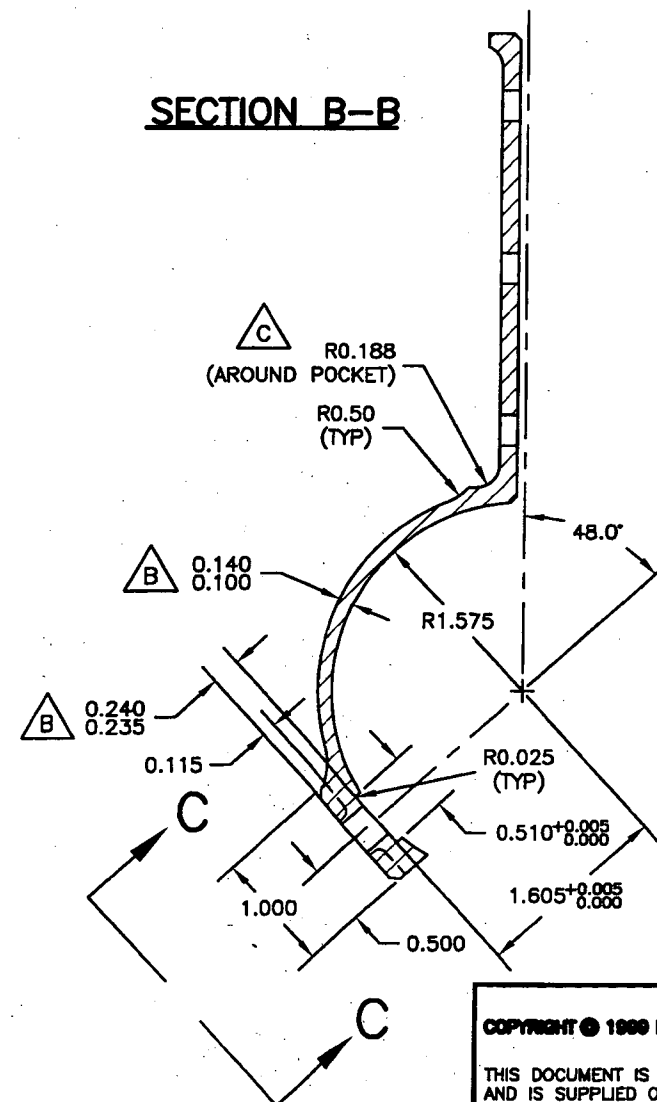
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 45884

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	DRAWING NO. D2932
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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RELEASED
 07-02-12

